

**Work Order ID 59630**

Wednesday, June 09, 2010 8:43:12 AM



Page 1

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10-6-09*

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInspec.  
Stamp

Draw Nbr:

Revision Nbr

D3793

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

*H3 10-6-22*

FLOW CNC Waterjet

*304 .040*1-Cut as per Dwg D3793    Dwg Rev: *A*    Prog Rev: *A*    2-  
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

*H3 10-6-22*

QC

Quality Control

120

QC8- Inspect parts - second check

0.00



Memo

0.00

*S.060622**(AB)*

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Wearshoe

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Brake NC

Memo

0.00

S6 10/06/23

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

E. Shoule/23

(13)

(73)

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powdercoat

Powder Coating

START TIME:

11:45

OVEN TEMPERATURE:

FINISH TIME:

D:15

300°

B R 10-8-28.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 59630**

Wednesday, June 09, 2010 8:43:12 AM



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Item ID: D3793-1

Revision ID:

Item Name: Wearshoe

Start Date: 6/9/2010 Start Qty: 12.00

Required Date: 6/17/2010 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: FP-18

0.00

10/06/29

13 0

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/29 XJ

10/06/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Wednesday, June 09, 2010 8:43:17 AM

Page 1

Work Order ID: 59630



Parent Item: D3793-1



Parent Item Name: Wearshoe

Start Date: 6/9/2010

Required Date: 6/17/2010

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Otv	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	107.9836	0.5902	7.455158	7.6		

304/316 .040 Sheet



Location	Loc Qty	Loc Code
MAT	104.1278	
	114574	114574
MAT20	3.8558	
	112885	
	2.7475	
	113062	(13)
	1.1083	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58630
Description: Wearshoe	Part Number:	D3793-1
Inspection Dwg: D3793	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article      Prototype

<b>Measured by:</b>	<b>Audited by:</b>	<b>Prototype Approval:</b>	N/A
Date:	10-6-22	Date:	10/06/22
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>
A	08.05.30	New Issue	KJ/DD

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

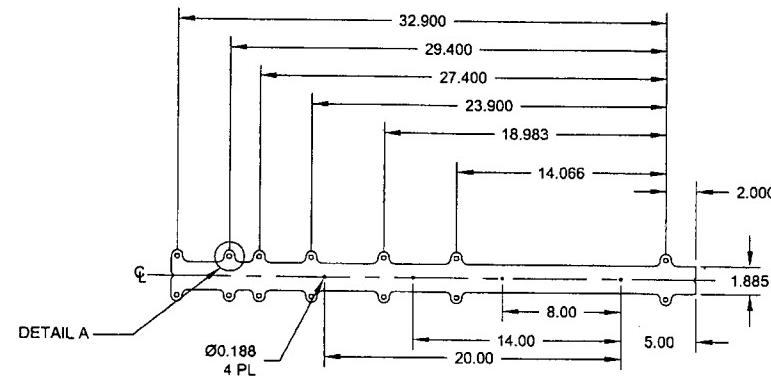
WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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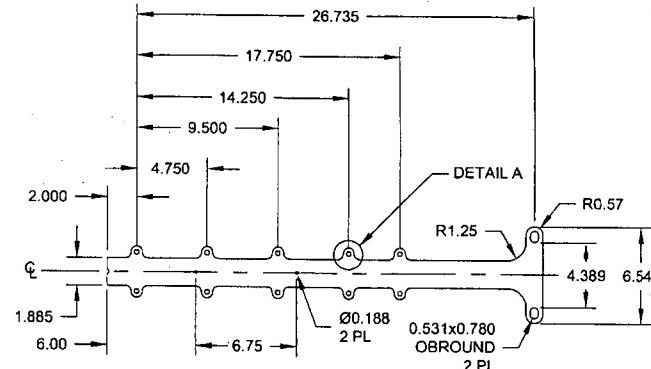
SHOCK  
RETURN TO  
ENGINEERING  
UNFILED C  
EFFECT 10 AMENDS

NO. 59630

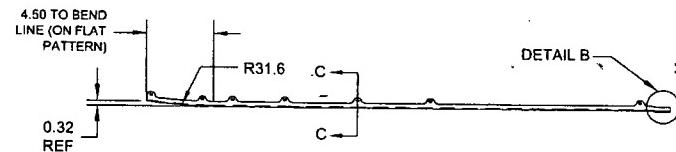
Brooklyn



**D3793-1F FLAT PATTERN**



D3793-3F FLAT PATTERN



**D3793-1 BEND DETAIL**



**D3793-3 BEND DETAILS**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)

2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "XXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH

7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC</b>		
DRAWN	<i>PH</i>	PORT HADLOCK, WA		
CHECKED	<i>S</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>S</i>	D3793	SHEET 1 OF 2	
APPROVED	<i>H</i>	TITLE	SCALE	
DE APPR.	<i>H</i>	WEARSHOE	NTS	
DATE	08.05.14		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THOSE RELATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

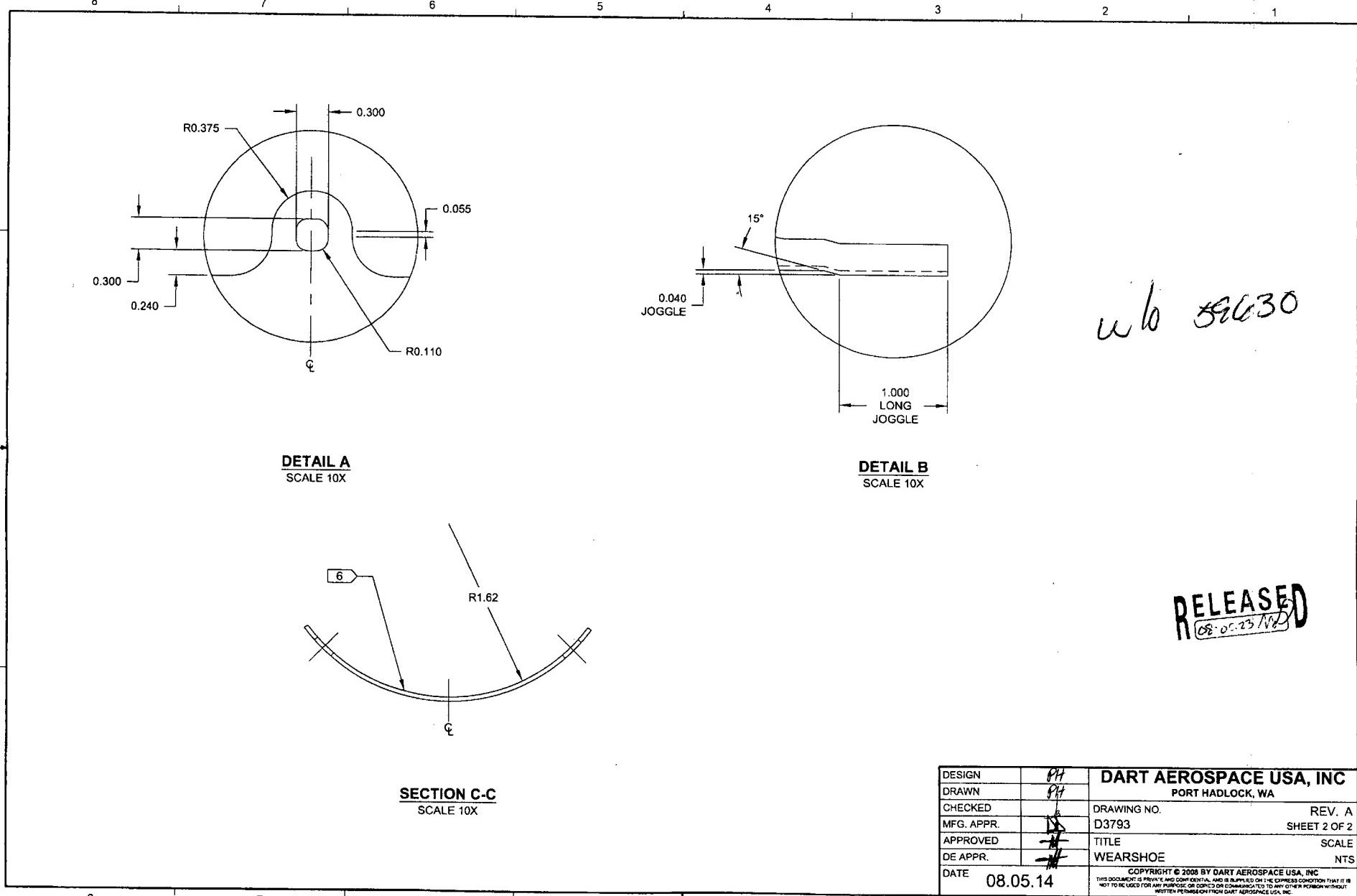
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